

Work Order ID 131259

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Item ID: D3601-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Radius Block
 Start Date: 4/01/15 Start Qty: 60.00 ***60*** Cust Item ID:
 Required Date: 4/08/15 Req'd Qty: 60.00 ***60*** Customer:
 Reference:

Approvals: Process Plan: W Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3601	Rev A								

100 0.00
100 SHEAR 8 15-4-7
 Shear Memo 0.00
 Shear blanks 9.00" long +/- 0.030" Note: 1 blank makes 8 pieces

110 0.00
110 HAAS CNC VERTICAL MACHINING #1 77 25 15-4-8
 HAAS 1 Memo 0.00
 HAAS CNC vertical machine #1 1- Mill as per Folio FA682 Rev: A & Dwg D3601 Rev: AA

120 0.00
120 QC2- Inspect parts off machine FAI/FAIB 77 25 15-4-8
 QC Memo 0.00
 Quality Control

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mf
15-4-13

Picklist Print

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Work Order ID: 131259

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Parent Item: D3601-1

D3601-1

Parent Item Name: Radius Block

Start Date: 4/01/15

Required Date: 4/08/15

Start Qty: 60.00

Required Qty: 60.00

Comments: IPP Rev:A New Issue 07-03-28 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B00750X00.1 25		Purchased	No				f	104.8500		4			

M6061T6B00750X00 125

6061-T6 Bar .750 x .125

**

SL154-7

Location

Loc Qty

Loc Code

MAT

80

M131653

80

MAT001

24.85

M127818

20.3

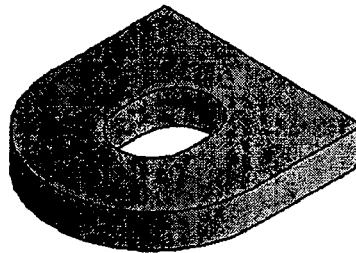
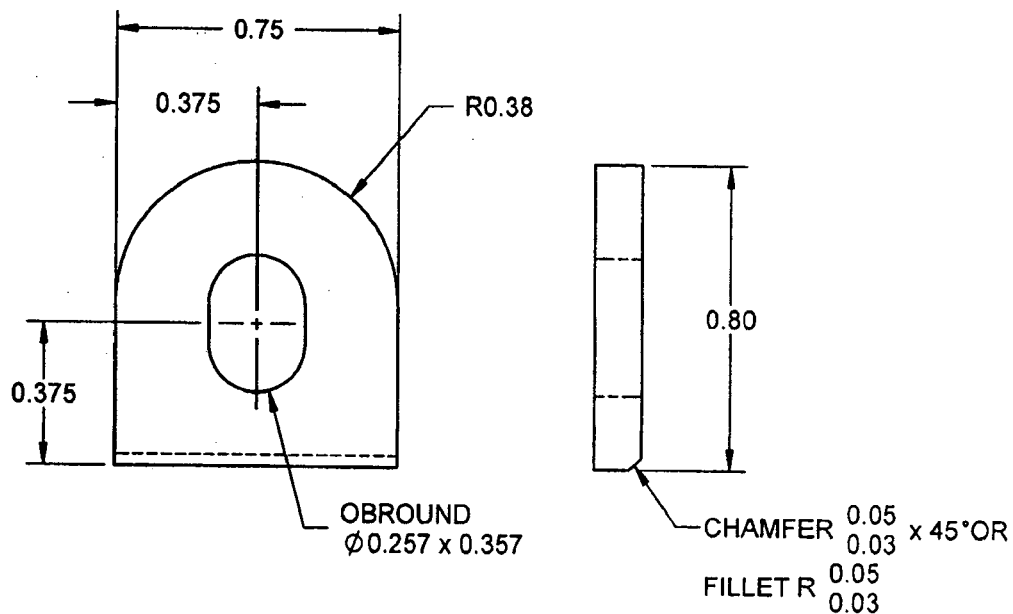
M129167

4.55

~~60.0~~

DART

DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3601	REV. A SHEET 1 OF 1
DATE 07.02.13	TITLE RADIUS BLOCK		SCALE 2:1
REV A	DATE 07.02.13	DESCRIPTION NEW ISSUE	

RELEASED07.03.08 *[Signature]**u/o*
131259**D3601-1 RADIUS BLOCK****NOTES:**

- 1) MATERIAL: ALUMINUM 5052-H32 SHEET, 0.125 THICK PER QQ-A-250/8 OR AMS 4016 (REF DART SPEC M5052H32S.125) OR ALUMINUM 6061-T6 SHEET, 0.125 THICK PER QQ-A-250/11 OR AMS 4025/4027 (REF DART SPEC M6061T6S.125)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3601-1" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.050 MAX

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